

Work Order ID 75576

75576

Page 1

October-25-11 3:11:20 PM

Item ID: D3324-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly
 Start Date: 25/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 08/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

*Nav.
gtr*

Approvals: Process Plan: M.L.J Date: 11/10/25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3324	Rev B								

100

100

Large Fab

Large Fab

Large Fab

Memo

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	<u>M109127</u>
4	D3324-3	Full Length Tube	
2	D3324-5	Top End Tube	<u>M109127</u>
2	D3324-7	Bottom End Tube	<u>M109127</u>
10	D3324-9	Vertical Tube	<u>M109127</u>

2- Weld as per dwg

A/R 4130 rod batch: M118875

PC 11.11.03 *(TX) X*

110

110

QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

Memo

0.00

1 0 22/11/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
121	Pressure Wash per QSI005 4.3	0.00							
121									
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten signature and date: 11/11/09

Handwritten signature and date: 11/11/09

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
130									
Powdercoat									
Powder Coating									
	Memo 1ST COAT: 2:00 START TIME: 2:00 OVEN TEMPERATURE: 400°F FINISH TIME: 2:30 ***** 2nd coat if necessary ***** 2ND COAT: 3:15 START TIME: 3:15 OVEN TEMPERATURE: 400°F 3:45								
140	QC3- Inspect Part Finish	0.00							
140									
QC									
Quality Control									

IXP m/f 11/11/04

11 - 11 - 04 (1)

M 118439

W/O:		WORK ORDER CHANGES					
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Item ID: D3324-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Basket Base Assembly

Stop ***NS2***

Start Date: 25/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 08/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location:

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

Signature: [Handwritten Signature]
Date: 11/11/07

Signature: [Handwritten Signature]
Date: 11/11/07

Signature: [Handwritten Signature]
Date: 11/11/07

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NOTE: Date & initial all entries

Picklist Print

October-25-11 3:11:25 PM

Page 1

Work Order ID: 75576

75576

Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 25/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3 *D3328-3* Basket Hinge		Manufactured	No			100	Each	24.0000	2	2	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA005		24								
			33872		24								
D3348-1 *D3348-1* Clevis		Manufactured	No			100	Each	5.0000	4	4	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA005		5								
			44246		5								
D3349-3 *D3349-3* Spacer Bushing		Manufactured	No			100	Each	10.0000	2	2	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA		10								
			72930		10								
D3367-1 *D3367-1* Mounting Bracket		Manufactured	No			100	Each	20.0000	2	2	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA005		20								
			43228		20								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

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Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 25/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

270.9988

46.6

49.05263

M4130NTS0 500W 035

4130 Square tube .500 x .500 x .035w

**

B119441

43.25

11/10/26

5.8 + 2.9 END BAR SCRAP

Location

Loc Qty

Loc Code

MAT034

270.9988

109127

216

109385

15.75

112786

39.2488

M569EX0.50-18F

Purchased

No

100

sf

78.0000

28

28

M569FX0 50-18F

569 Expanded Metal

**

11/10/27

Location

Loc Qty

Loc Code

MAT018

78

112776

10

117806

4

119226

64

22.25

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Shop Packet Print

Page 2

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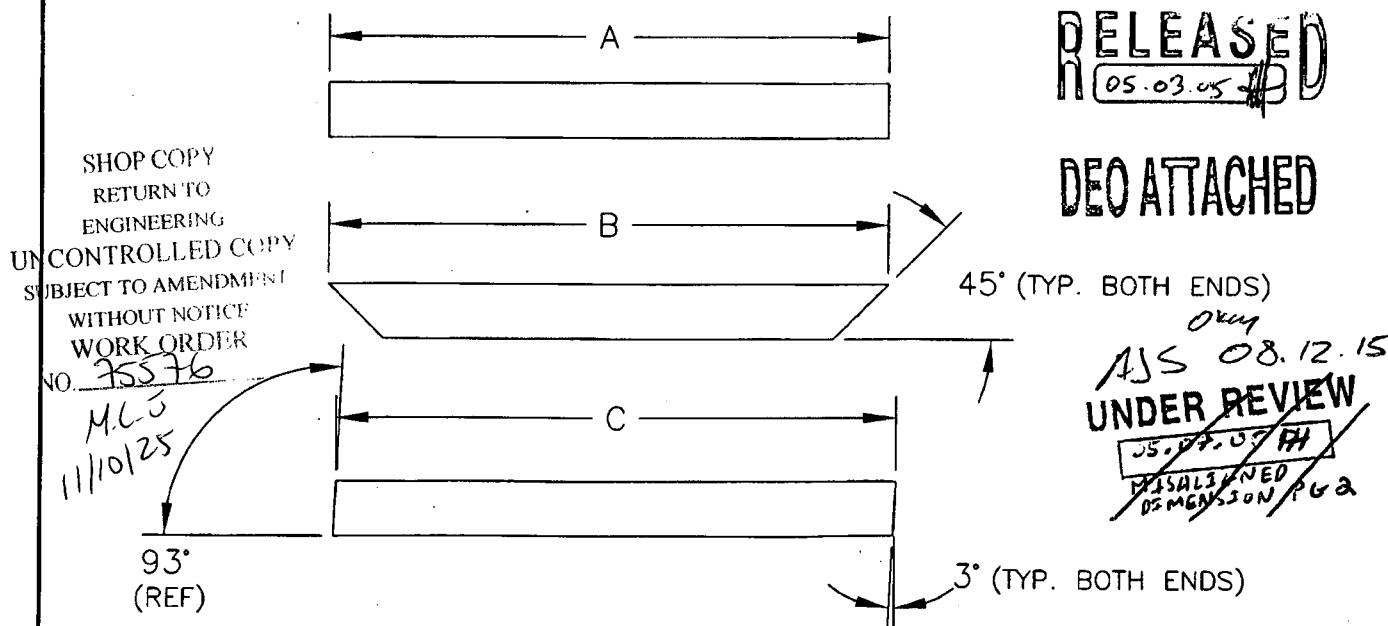
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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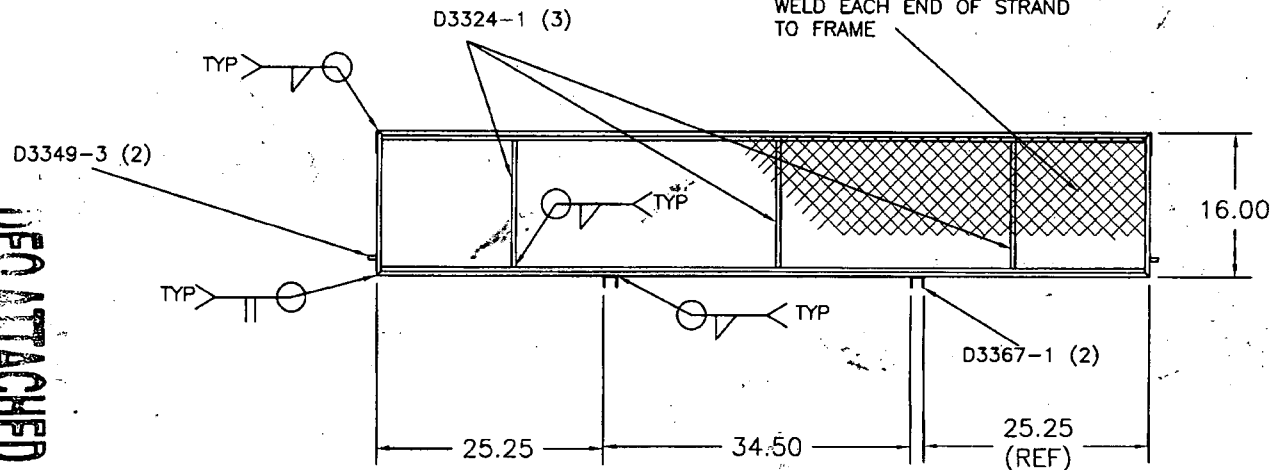
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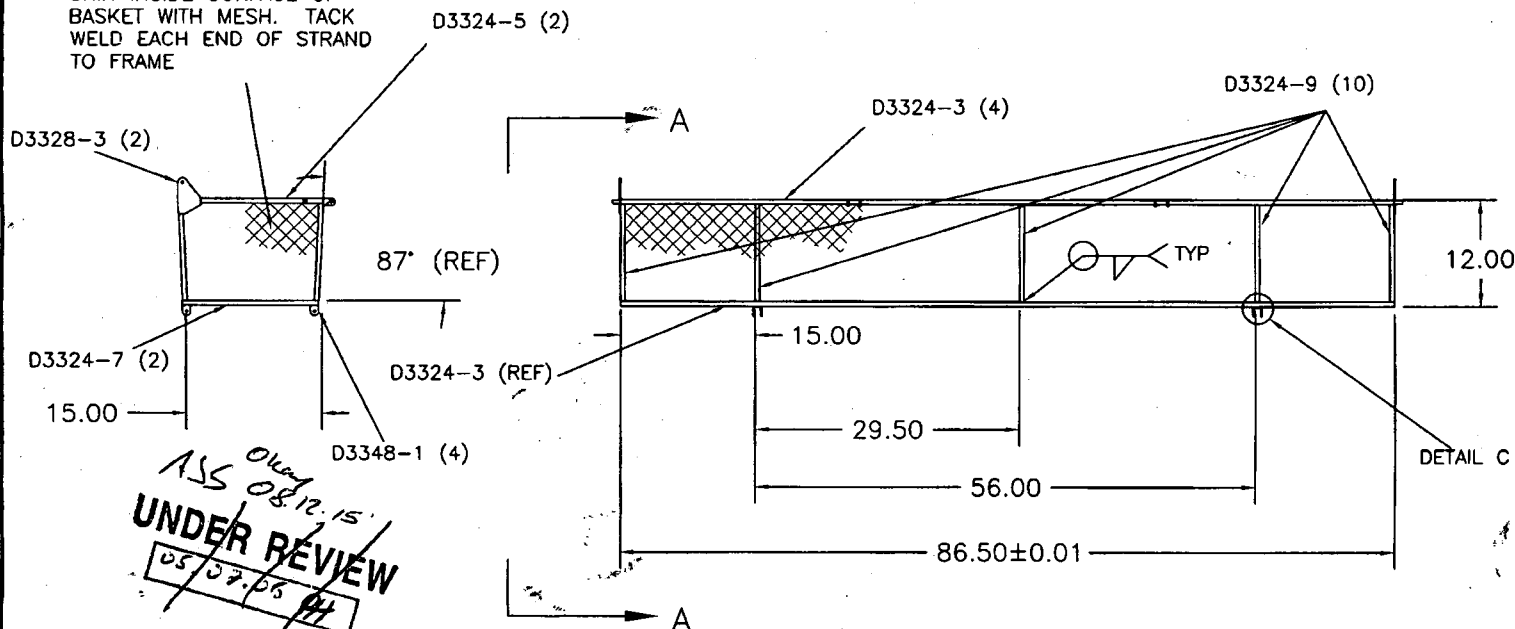


DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	
DATE	05.03.04	TITLE	BASKET BASE ASSEMBLY	
		DRAWING NO.	D3324	
				REV. B
				SHEET 2 OF 3
				SCALE
				1:20

SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

RELEASED
05.03.05

DETACHED

ASS 08.12.15
UNDER REVIEW
05.07.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

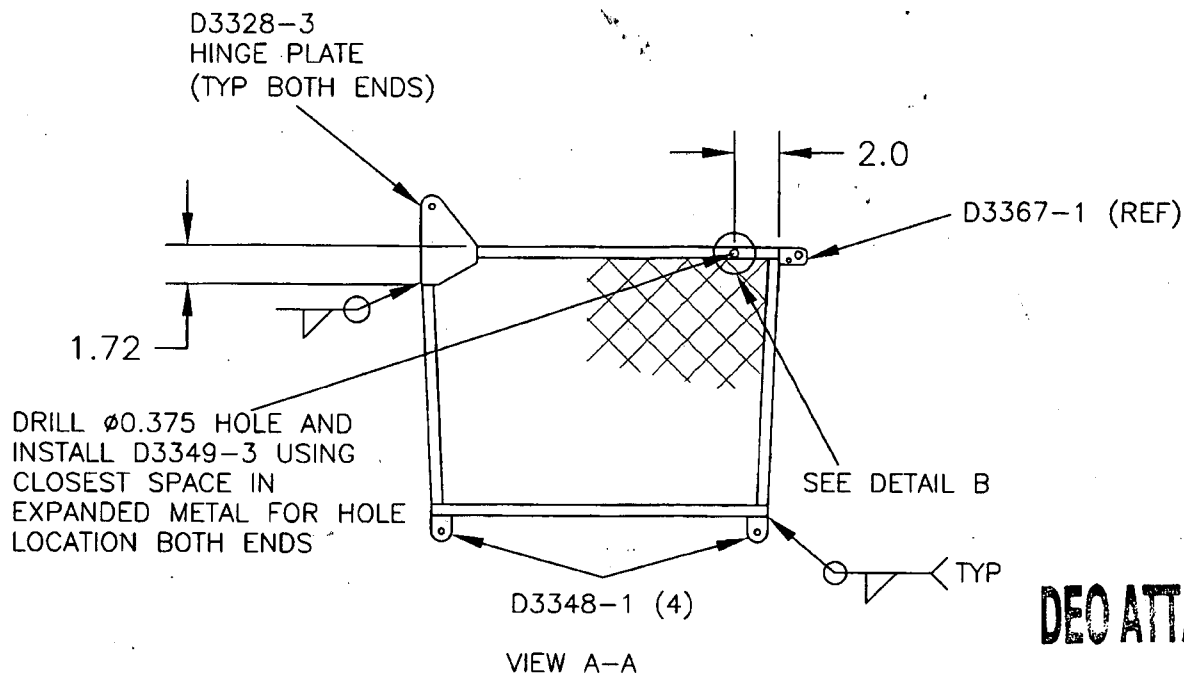
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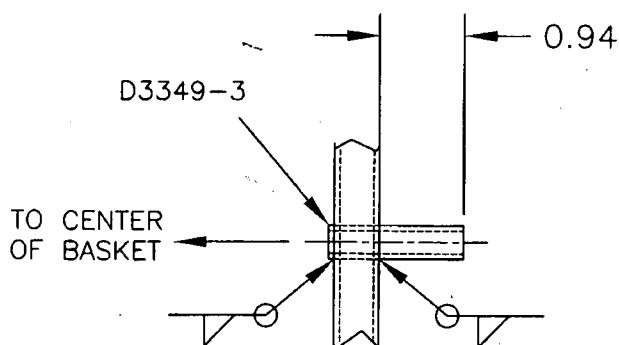
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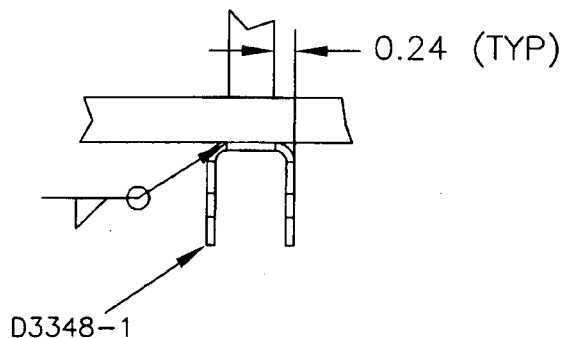
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



RELEASED
05.03.05



DETAIL B
(SCALE 1:2)



DETAIL C
(SCALE 1:2)

Okay
155 08.12.15
UNDER REVIEW
05.07.05

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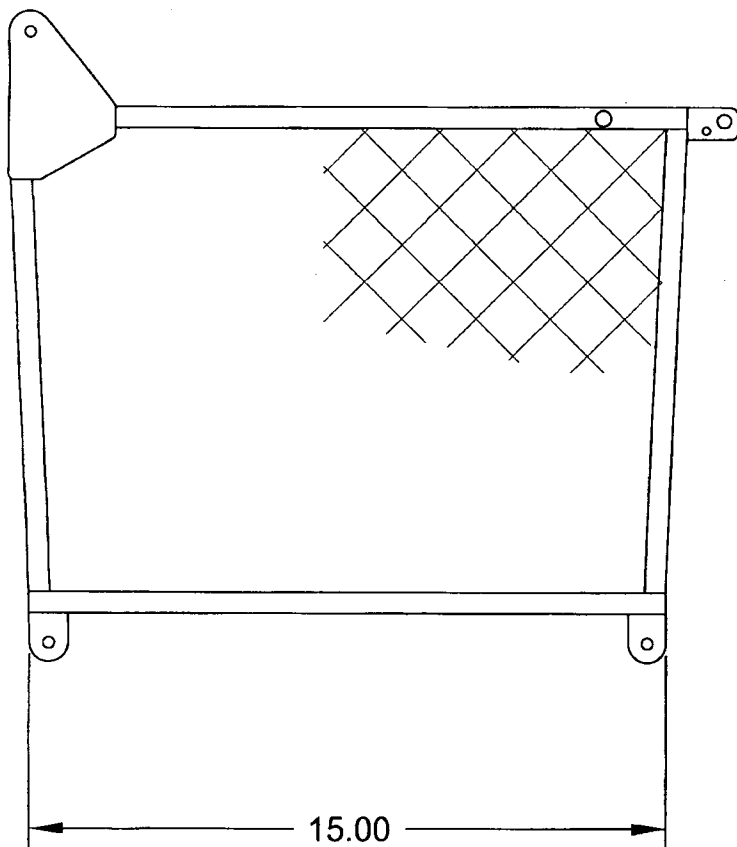
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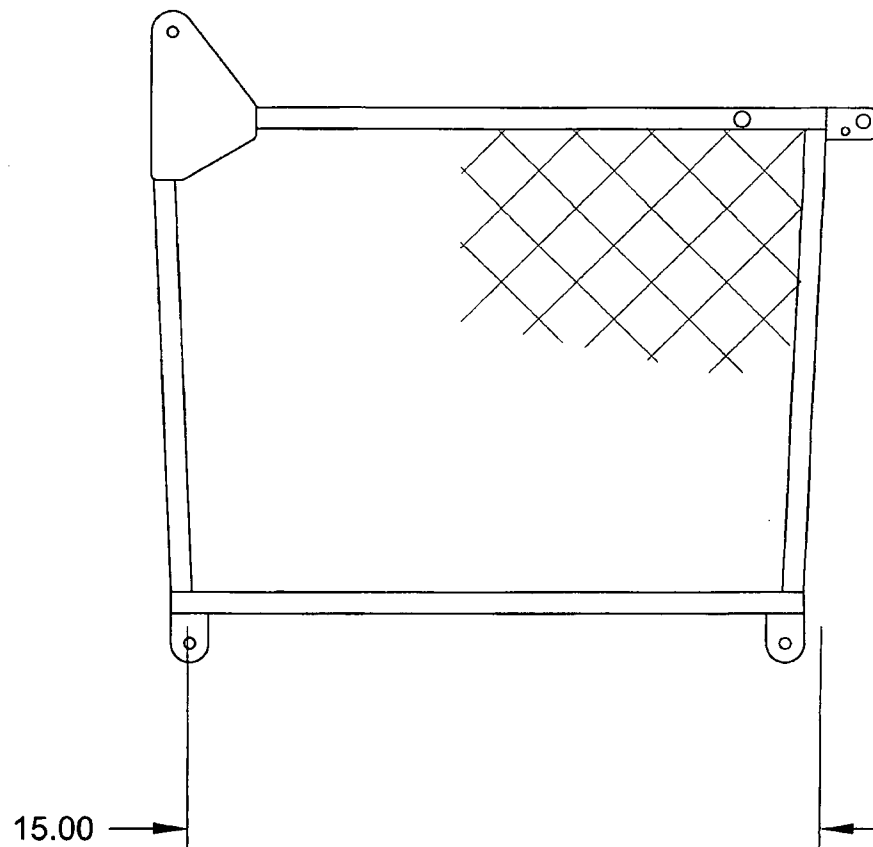
DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.28	DATE 08.11.28	DATE 08/12/01	DATE 08/12/01		DATE 08.12.01		

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



W/O:		WORK ORDER CHANGES					
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